

fresh

Work Order ID 77815

77815

Page 1

December-21-11 3:39:48 PM

Item ID: D3307-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Gasket
Start Date: 21/12/2011 Start Qty: 6.00 *6* Cust Item ID:
Required Date: 05/01/2012 Req'd Qty: 6.00 *6* Customer:
Reference:

Approvals: Process Plan: MLJ Date: 11/12/21 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3307	Rev A								

100 0.00
100 FLOW WATER JET
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3307 Dwg Rev: A Prog Rev: A 2-
Surf Black Deburr if necessary

B12-1-2

8

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.00
Quality Control

B12-1-2

120 0.00
120 QC8- Inspect parts - second check
QC Memo 0.00
Quality Control

S 12/07/03

78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Gasket

Start Date: 21/12/2011 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 05/01/2012 **Req'd Qty:** 6.00

6

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: 5-232A -0.00

-0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

CK 12/01/04

mf
12-01-03

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

December-21-11 3:39:52 PM

Page 1

Work Order ID: 77815

77815

Parent Item: D3307-3

D3307-3

Parent Item Name: Gasket

Start Date: 21/12/2011

Required Date: 05/01/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: A04.09.24New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245		Manufactured	No			100	Each	14.7140	0.257	1.623158	2.5		
D3245									**		1812-1-2		
Gasket													

Location

Loc Qty

Loc Code

MAT052

14.714

69232

14.714

69232

8

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	77815
Description: Gasket		Part Number:	D3307-3
Inspection Dwg: D3307 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.745	✓		V BOZ	
5.50	+/-0.030	5.491	✓		V	
6.66	+/-0.030	6.646	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-1-2	Date: 12/01/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.10.24	New Issue	KJ/DD	DB

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

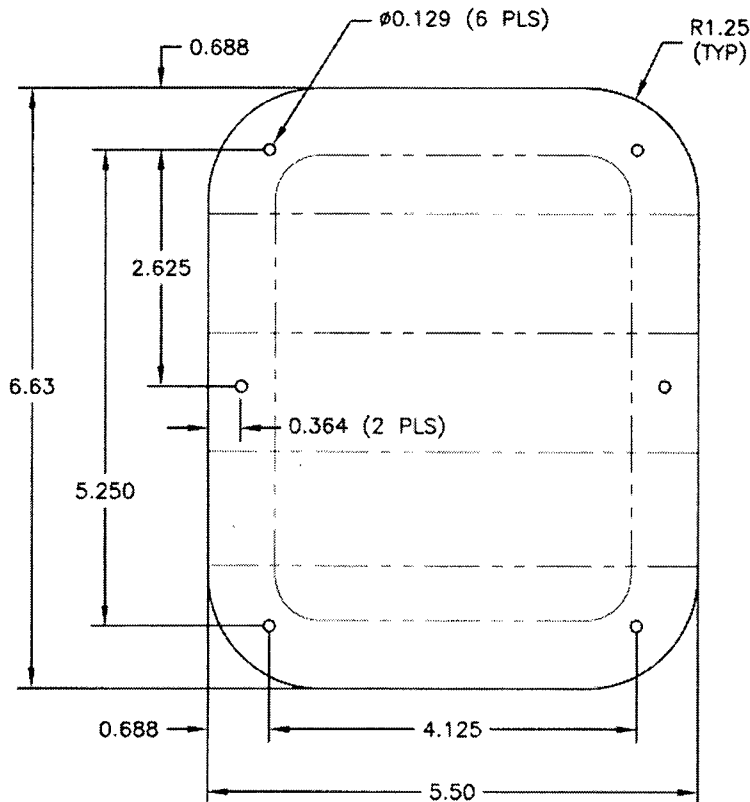
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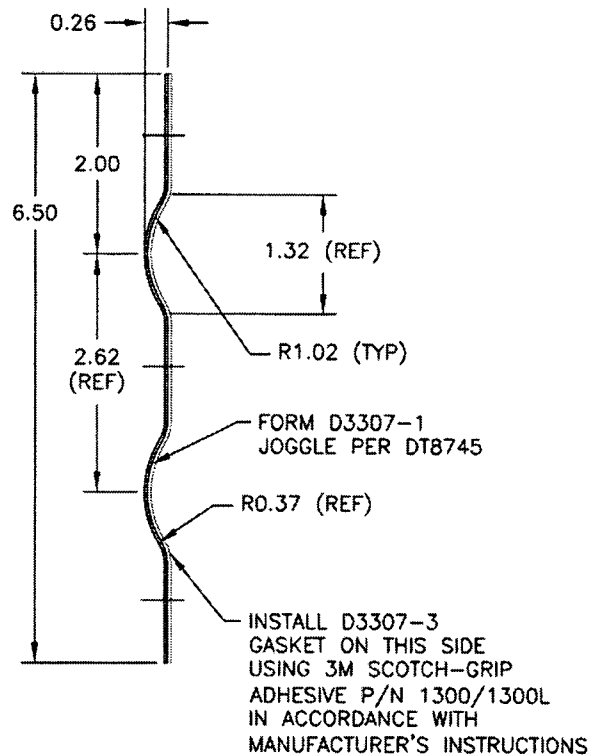


DESIGN R	DRAWN BY R	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3307	REV. A SHEET 1 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2
A	04.09.23	NEW ISSUE	

RELEASED
05.01.18



D3307-1 PANEL FLAT PATTERN



D3307-041 BEND DETAIL

IDENTIFY WITH P/N & B/N
USING FINE POINT
PERMANENT MARKER

D3307-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK ANNEALED (REF. M304S22GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 11/12/21
H.C.5

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

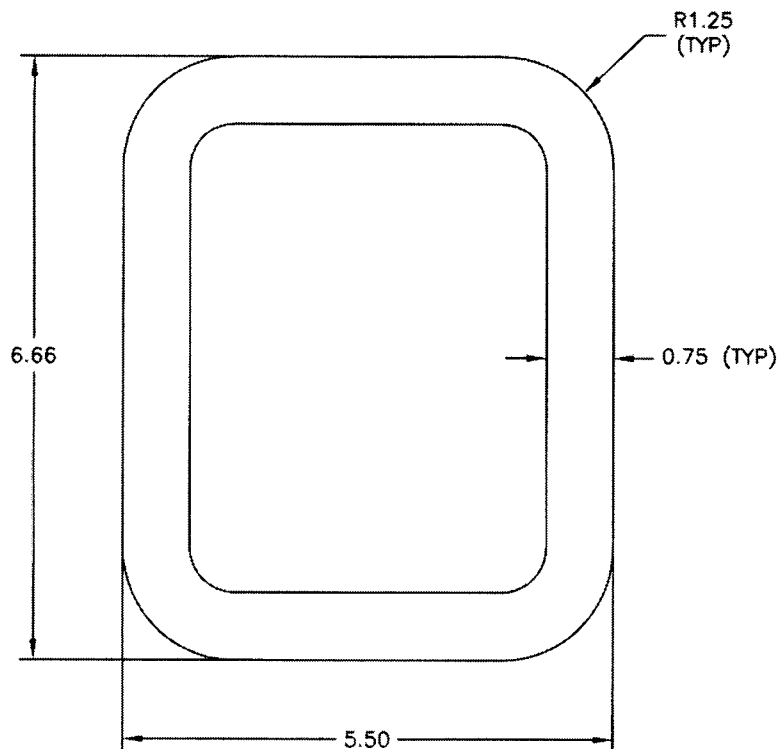
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3307	REV. A SHEET 2 OF 2
DATE 04.09.23		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:2

RELEASED
05.01.18 [Signature]



D3307-3 GASKET

D3307-3 NOTES:

- 1) MATERIAL: DURABLA BLACK GASKET 0.035 THICK MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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51815

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